

IN THE CLAIMS

Upon entry of the present amendment, the status of the claims will be as is shown below. This listing of claims will replace all prior versions and listings of claims in the application:

1. (Currently Amended) A method for laser drilling a hole in a multi-layered sheet-like material, the method comprising:

drilling through all layers of the material by at least one laser pulse having a first energy, which generates an inter-layer pull-off force smaller than an inter-layer adhesion force of the multi-layered sheet; and

trimming a shape of the hole by at least one laser pulse having a second energy higher than the first energy, an interval between the at least one pulse having a first energy and the at least one pulse having a second energy being approximately 200  $\mu$ S ~~the first energy being within a range of approximately 1/7 to 7/25 of the second energy.~~

2. (Previously Presented) The method for laser drilling according to claim 1, further comprising controlling at least one of the first energy and the second energy by changing a laser pulse width.

3. (Previously Presented) The method for laser drilling according to claim 1, further comprising controlling at least one of the first energy and the second energy by changing a peak value.

4. (Withdrawn) A laser drilling apparatus comprising:  
a laser oscillator;  
a control device for supplying the laser oscillator with pulses of pulsed laser beams;  
a system for supplying laser pulse trains to the control device for forming a hole in a multi layered sheet-like material, the laser pulse trains having energy that generates an inter-layer pull-off force smaller than an inter-layer adhesion force; and  
a system for supplying laser pulses to the control device for trimming the hole, the laser pulses having energy higher than that of the laser pulse trains.

5. (Currently Amended) A method for laser drilling a hole in a multi-layered sheet-like material, the method comprising:

drilling through all layers of the material by at least one laser pulse having a first energy, which generates an inter-layer pull-off force smaller than an inter-layer adhesion force of the multi-layered sheet; and

trimming a shape of the hole by at least one laser pulse having a second energy higher than the first energy, an interval between the at least one pulse having a first energy and the at least one pulse having a second energy being at least 200  $\mu$ S ~~the first energy being within a range of approximately 1/35 to 2/25 of the second energy.~~

6. (Previously Presented) The method for laser drilling according to claim 5, further comprising controlling at least one of the first energy and the second energy by changing a laser pulse width.

7. (Previously Presented) The method for laser drilling according to claim 5, further comprising controlling at least one of the first energy and the second energy by changing a laser pulse peak value.

8. (Currently Amended) A method for laser drilling a hole, having at least one of a predetermined shape and size, through a material comprising a plurality of layers, the method comprising:

drilling an initial hole through all of the plurality of layers of the material using a first laser pulse train, the first laser pulse train comprising at least one laser pulse having a first energy that generates an inter-layer pull-off force smaller than an inter-layer adhesion force between at least two of the plurality of layers; and

trimming the initial hole to the at least one of the predetermined shape and size of the hole, using a second laser pulse train comprising at least one laser pulse having a second energy, which is greater than the first energy, an interval between the at least one pulse having a first energy and the at least one pulse having a second energy being at least 200  $\mu$ S.

9. (Currently Amended) The method for laser drilling according to claim 8, wherein the second energy generates an inter-layer pull-off force greater than the inter-layer adhesion

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force between the at least two of the plurality of layers, ~~the inter-layer pull-off force of the~~ second energy being vented through the initial hole, preventing delamination of the at least two of the plurality of layers.

10. (Previously Presented) The method for laser drilling according to claim 8, further comprising controlling at least one of the first energy and the second energy by changing a laser pulse width.

11. (Previously Presented) The method for laser drilling according to claim 8, further comprising controlling at least one of the first energy and the second energy by changing a laser pulse peak value.